

Work Order ID 61993

Wednesday, September 15, 2010 9:49:08 AM



Page 1

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 9/14/2010 Start Qty: 8.00

Required Date: 9/21/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: 1/

Date: 10-9-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4091

A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

20 10/09/28

20

Ø

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: AA

DWG REV: A

0.00

20 10/09/29

20

Ø

B.A 10/09/30

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

H.A

10/09/30

20

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

aml 10/09/30

20

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

ell 10/10/10

20

0



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Page 4

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Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 9/14/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05 *[Signature]*
CL 10/10/05

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Picklist Print

Wednesday, September 15, 2010 9:50:16 AM

Page 1

Work Order ID: 61993



Parent Item: D4091-1



Parent Item Name: Mounting Lug


Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	364.5171	0.1251	1.053474		28 10/09/28	

Location

Loc Qty

Loc Code

MAT06

364.5170795

43722

180

45800

184.517079

1.0535

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DART AEROSPACE LTD		Work Order: 61993
Description: Mounting Lug		Part Number: D4091-1
Inspection Dwg: D4091	Rev: a	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030	1.379	✓		Vern SF-12	
4.45	+/-0.030	4.452	✓		" "	
0.27 REF	+/-0.030	.266	✓		High gauge	
1.91	+/-0.030	1.911	✓		High gauge	
0.69	+/-0.030	.690	✓		High gauge	
0.293	+/-0.010	.293	✓		Vern SF-12	
0.735 REF	+/-0.010	.725	✓		"	
0.375	+/-0.010	.375	✓		"	
3.700	+/-0.010	3.700	✓		"	
0.625	+/-0.010	.625	✓		"	
0.375	+/-0.010	.375	✓		"	
Ø0.257	+0.006/-0.001	.259	✓		"	
R0.40	+/-0.030	.40	✓			
2.310 REF	+/-0.010	2.313	✓		High gauge	

Measured by: SS/H.A	Audited by: ONL	Preliminary Approval:
Date: 10/29/29	Date: 10/09/30	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.05	New Issue	KJ	AA

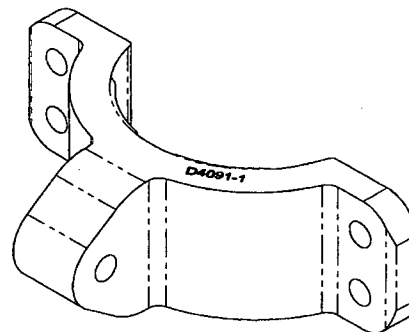
W/O:		WORK ORDER CHANGES					
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D4091-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITH
WORK
NO. *41993*
BS109-B

RELEASED
2010-04-28
WP

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	D4091	REV. A	
MFG. APPR.				SHEET 1 OF 2	
APPROVED		TITLE	MOUNTING LUG	SCALE	
DE APPR.				NTS	
DATE	10.03.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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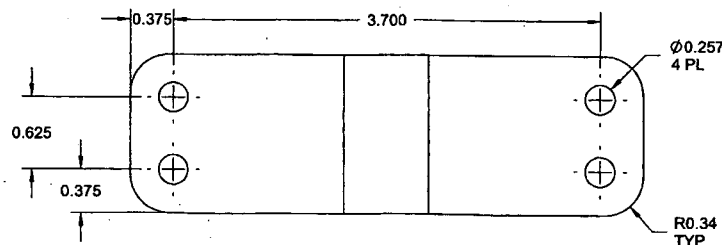
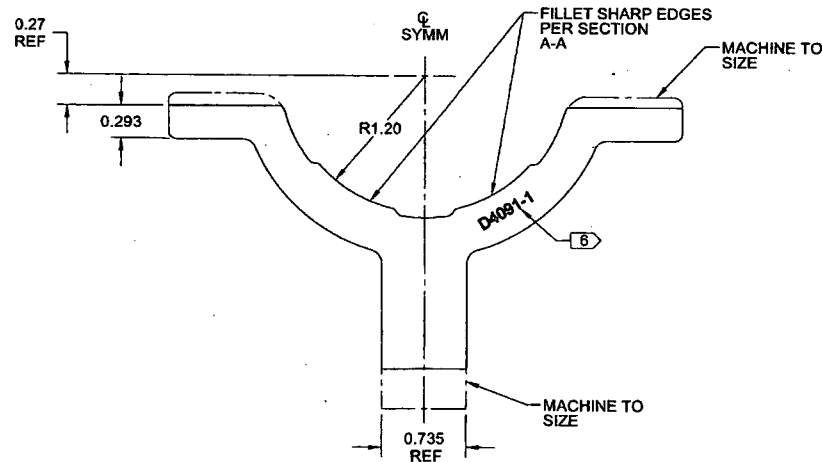
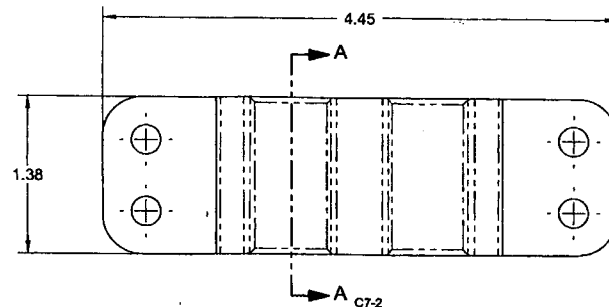
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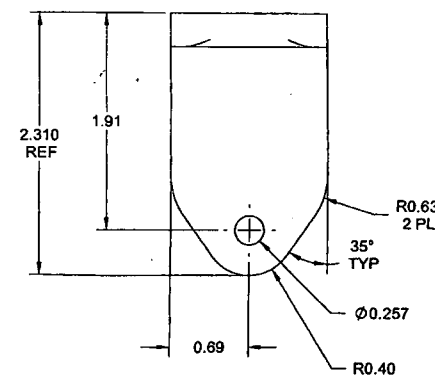
R0.03-R0.07
TYP AROUND PAD

SECTION A-A
C5-2

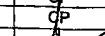


D4091-1 MOUNTING LUG

STAMP COPY
RECEIVED
BY
UNITED STATES OF AMERICA
SPECIAL AGENT
IN CHARGE
WORK
NO. 41993



RELEASED
2010-04-20
AM

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4091	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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